



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D206-642-341BL
Job Sheet 192087



Part No: D206-642-341BL

Job Qty: 1 pcs

Part Name: Replacement Skidtube (Fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/15/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2650 REV.F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC ver: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD ver: JLM IPP Rev: M 14.04.25 Ecn14-520 DD ver: JLM IPP REV: N 15.10.09 ADDED BL DD VERF: JLM IPP REV: O 16.01.22 PAR16-484 DD VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	4/19/19		0.00	1.58	Skidtubes - 1		TF HE
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
115	QC 5	1 pcs	4/19/19		0.00	0.00	QC 5 - 10		D 19.01.01
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
116	QC 9	1 pcs	4/19/19		0.00	0.00	QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		

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Container No: S165816



Part: D206-642-341BL

Job No: 192087

Serial No/Batch: S165816

Revision: F(deo)

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, EASA STC SH98-4 Issue 2, EASA STC

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https://www.plexonline.com/0fd03885-06ca-4212-bdec-325154c96cfb/Plexus_Control/Report_Viewor_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 3/7

205 QC 6	1 pcs	4/19/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 14 - 15	HL 19-5-17
210 QC 14	1 pcs	4/19/19	0.00 0.00	QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				Handfinish - 4 - 1 - B4B	HL 14-5-20
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
220 Handfinish - 4-1-Assembly-B4B	1 pcs	4/19/19	0.00 1.17	Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 3 - 10	
230 QC 3	1 pcs	4/19/19	0.00 0.00	QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 5 - 10	
240 QC 5	1 pcs	4/19/19	0.00 0.00	QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	

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as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 13-Deburr.
115 - QC5- Inspect part completeness to step on W/O
116 - QC9- Inspect visual per QSI004- Fusion Welds
120 - Chemical Conversion Coat per QSI005 4.1
125 - QC7-Inspect Chemical Conversion Coat
130 - Skidtubes - 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: 04/25/19 Time: 8:00am Finish Date: 04/25/19 Time: 8:00pm A/R Sikaflex-291 5163437 Sikaflex expiry date: 12.09.19
140 - QC5- Inspect part completeness to step on W/O
150 - Skidtubes - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002
180 - QC5- Inspect part completeness to step on W/O
190 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
200 - ISSUE PO _____ Prime and Paint DELFLEET BLUE Prime: 5171337 Blue: 5156229 Clear: 5173359
205 - QC6- All purchased or subcontracted products
210 - QC14- Inspect Spray Paint
220 - HandFinish4 (Assemble as per dwg - 1-Install Inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R Sikaflex-291 5163334 Sikaflex expiry date: 14-12-11 2- Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06 Screw 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R Sikaflex-291 5163334 Sikaflex expiry date: 14-12-11 6- Install D2680-041 Nut Plate as per Dwg D2650 7-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: 5163430
230 - QC3- Inspect Part Finish
240 - QC5- Inspect part completeness to step on W/O
250 - Identify and pack for shipping as per PPP D206-642-341 Location:FG083
255 - Document Control - Photocopy bluefile and create labels per PPP D206-642-341 CHG005
260 - QC21- Final Inspection - Work Order Release

Job BOM

009772

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	5150650
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5089985
D2654-5	Web	1 pcs (1 ea)	130-Skidtubes - 2 - B4B	5173849
D4720-1	Spacer	19 pcs (19 ea)	150-Skidtubes - 3 - B4B	5154879
ALS4-1032-130	Rivnut	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	5057267
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	F41137627
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	F41137886-0
D2646BL	Aft Cap	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5173725
D2651-1BL	Plug	14 pcs (14 ea)	220-Handfinish - 4-1-Assembly-B4B	5167942
D2651-3	O-Ring	14 pcs (14 ea)	220-Handfinish - 4-1-Assembly-B4B	5044502
D2680-041BL	Nut Plate	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5166112
D3537-1	Wearpad	6 pcs (6 ea)	220-Handfinish - 4-1-Assembly-B4B	5174742
D3537-3	Wearpad	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	514665
D4956-11	Wearplate Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	X174847
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5171522
D4956-35	Wearplate Aft	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5175578
MS27039-1-08	Screw	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5153202
MS27039-4-06	Screw	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5166574-1
MS27039C1-08	Screw	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	5167302
NAS1149C0332R	Washer	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B	5148669
NAS1149D0332J	Washer	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5123416
NAS1149D0463J	Washer	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5152588

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	10	0
	D2647	1	8	0
130-Skidtubes - 2 - B4B	D2654-5	1	11	0
150-Skidtubes - 3 - B4B	D4720-1	19	383	0
220-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	54	9,221	0
	CCR264SS3-3	2	243	0
	CR3212-4-03	2	120	0
	D2646BL	1	5	0
	D2651-1BL	14	54	0
	D2651-3	14	382	0
	D2680-041BL	1	0	0
	D3537-1	6	45	0
	D3537-3	1	22	0
	D4956-11	1	11	0
	D4956-23	1	6	0
	D4956-35	1	1	0
	MS27039-1-08	2	546	0
	MS27039-4-06	1	13	0
	MS27039C1-08	54	420	0
	NAS1149C0332R	54	5,103	0
	NAS1149D0332J	2	2,991	0
	NAS1149D0463J	1	6,901	0
Part Specifications				
Specifications could not be found.				

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QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
X				D2860-1	SKIDTUBE ASSEMBLY
	X			D2860-3	SKIDTUBE ASSEMBLY
		X		D2860-5	SKIDTUBE ASSEMBLY
			X	D2860-7	SKIDTUBE ASSEMBLY
					EXTRUSION
1	1	1	1	D2860-1-160	WEB
1				D2854-1	WEB
	1			D2854-3	WEB
		1		D2854-5	WEB
			1	D2854-7	WEB
1	1	1	1	D2648	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2660-041	NUT PLATE
2	2			D3298-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	AL57-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
				AN96JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN66JD416	WASHER
52	52			CR3212-4-04	RIVET

F

NOTES:

1) MATERIAL: N/A

2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER

DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) WELD PER DART QSI 004

9) DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/251 ADHESIVE PER DART QSI 015

11) INSERT D2661-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

12) DRILL Ø0.287 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

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19-03-15

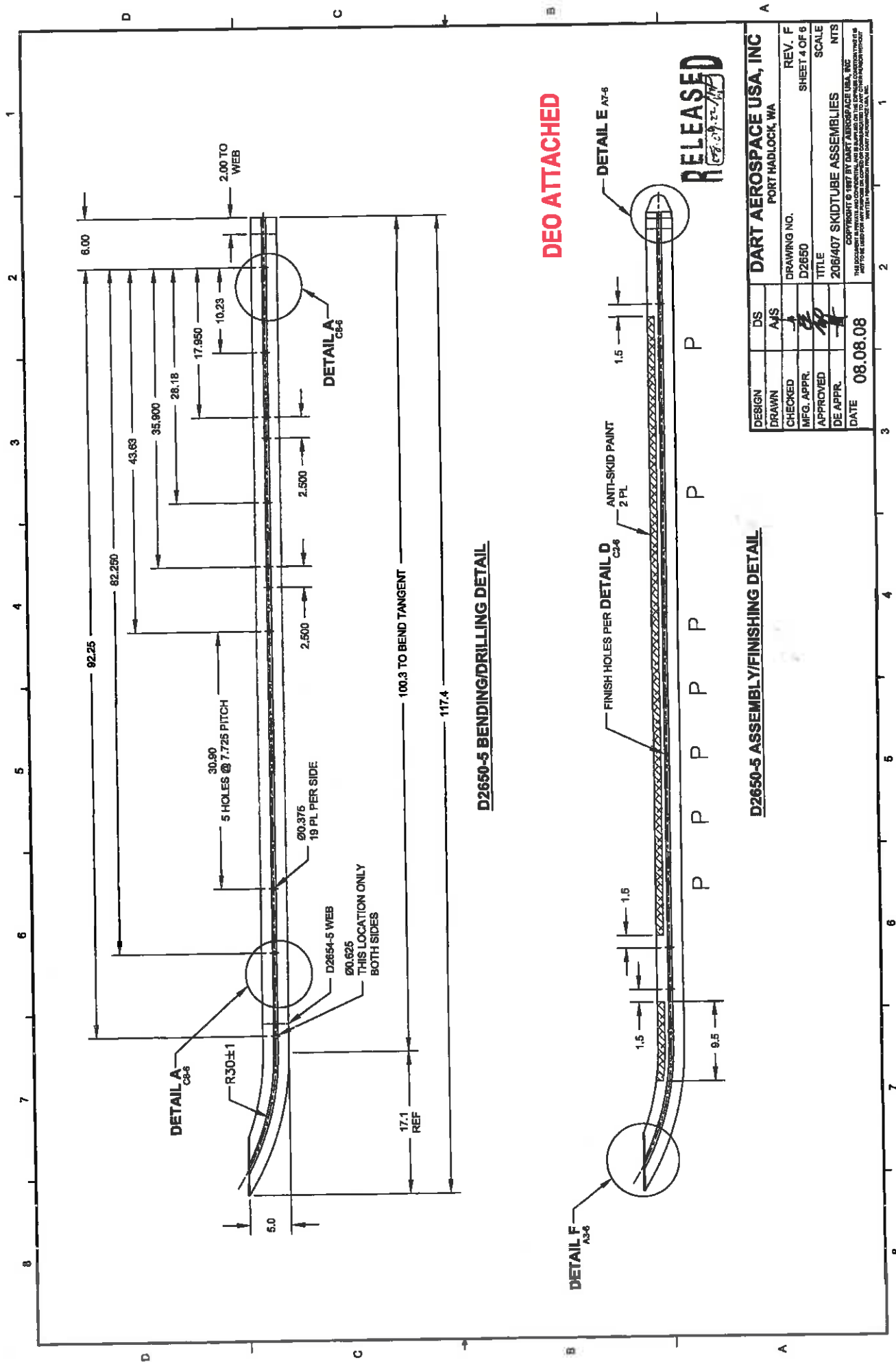
DEO ATTACHED

RELEASED
11/08/23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 8 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6, SHT 1 IN PL PART D2849 QTY UPDATED. SHT 8 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	06.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCORP. DEOR1369153/163	CP	04.05.17
C	MOD GROUND HANDLING ON D2850-1/3	DS	97.10.29
B	CHANGE HOLE PATTERN AND FRONT END	DS	97.06.26
A	AS MANUFACTURED CHANGES	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.08		
DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWING NO. D2850			
TITLE 208/407 SKIDTUBE ASSEMBLIES			
REV. F SHEET 1 OF 9			
SCALE NTS			
COPYRIGHT © 1987 BY DART AEROSPACE USA, INC			
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DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS	DRAWING NO.	REV. F
CHECKED	<i>[Signature]</i>	D2660	SHEET 2 OF 6
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	208/407 SKIDTUBE ASSEMBLIES	NTS
DE APPR.		COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	
DATE	08.08.08	1. THE INFORMATION CONTAINED HEREIN IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS TO BE USED FOR THE SPECIFIC PROJECT AND PURPOSE FOR WHICH IT WAS CREATED. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

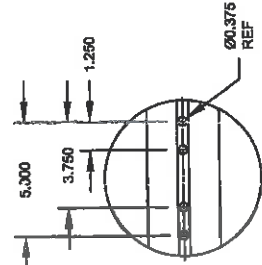


D2650-5 BENDING/DRILLING DETAIL

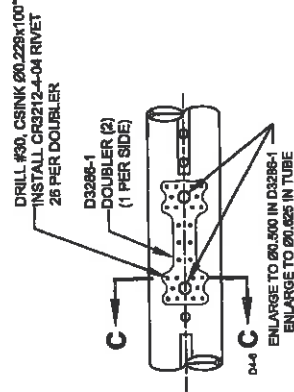
D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO.
MFG. APPR.		D2650
APPROVED		TITLE
DE APPR.		206407 SKIDTUBE ASSEMBLIES
DATE	08.08.08	SCALE
		NTS

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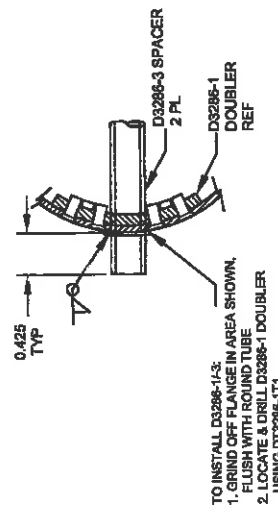


DETAIL A CS2
SCALE 2X
D72
D73
D74
D75
D76

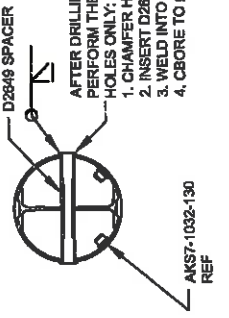


DETAIL B CS2
SCALE 2X CS3

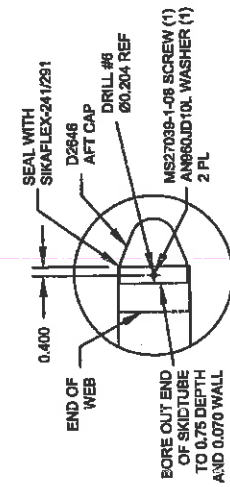
SECTION C-C C748
SCALE NONE



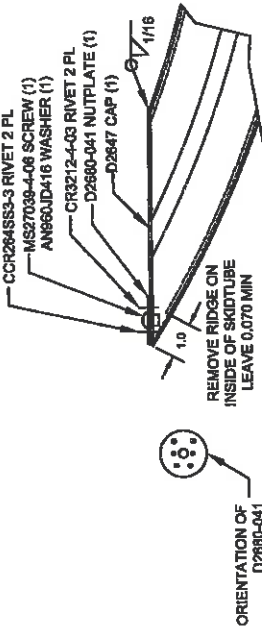
TO INSTALL D3286-1/3:
1. GRIND OFF FLARE IN AREA SHOWN.
2. LOCATE & DRILL D3286-1 DOUBLER USING DT2286-1T1.
3. ENLARGE HOLES IN D3286-1 TO 0.00500
AND CHAMFER HOLES IN TUBE TO 0.00625
4. ENLARGE HOLES IN TUBE TO 0.00625
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE.



DETAIL D B42
FOR 0.0375 HOLES ONLY
SCALE 3X B43
B44
B45



DETAIL E B22
SCALE 2X B23
B14
B15



DETAIL F B62
SCALE NONE B63
B64
B65

DETAIL F NOTES:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2847 (TRIM AS NECESSARY)
4. WELD D2847 IN PLACE PER DART CSI 004
5. GRIND FLUSH
6. RIVET D2880-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D2880-041 PRIOR TO FINISH

ORIENTATION OF D2880-041

REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN

1/16

MS27038-1-08 SCREW (1)
AN660JDTOL WASHER (1)
CR3212-4-03 RIVET 2 PL
D2880-041 NUTPLATE (1)
D2847 CAP (1)

CCR2845SS3-3 RIVET 2 PL

MS27038-1-08 SCREW (1)
AN660JDTOL WASHER (1)

CR3212-4-03 RIVET 2 PL

D2880-041 NUTPLATE (1)

D2847 CAP (1)

CCR2845SS3-3 RIVET 2 PL

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AN660JDTOL WASHER (1)

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D2880-041 NUTPLATE (1)

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AN660JDTOL WASHER (1)

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D2880-041 NUTPLATE (1)

D2847 CAP (1)

CCR2845SS3-3 RIVET 2 PL

MS27038-1-08 SCREW (1)
AN660JDTOL WASHER (1)

CR3212-4-03 RIVET 2 PL

D2880-041 NUTPLATE (1)

D2847 CAP (1)

CCR2845SS3-3 RIVET 2 PL

MS27038-1-08 SCREW (1)
AN660JDTOL WASHER (1)

CR3212-4-03 RIVET 2 PL

D2880-041 NUTPLATE (1)

D2847 CAP (1)

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MS27038-1-08 SCREW (1)
AN660JDTOL WASHER (1)

CR3212-4-03 RIVET 2 PL

D2880-041 NUTPLATE (1)

D2847 CAP (1)

CCR2845SS3-3

DRAWING NO.	TITLE	REV. F	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D2650	206/407 SKIDTUBE ASSEMBLIES		ENGINEERING ORDER	D2650-F-1	SHEET 1 OF 1	NTS
DRAWN	CHECKED	A.O.	MFG. APPR.	APPROVED	DE APPR.	
DATE	12.10.12	DATE	12.10.22	DATE	12.10.22	DATE

PURPOSE:
CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:
PARTS LIST IS AMENDED AS FOLLOWS:

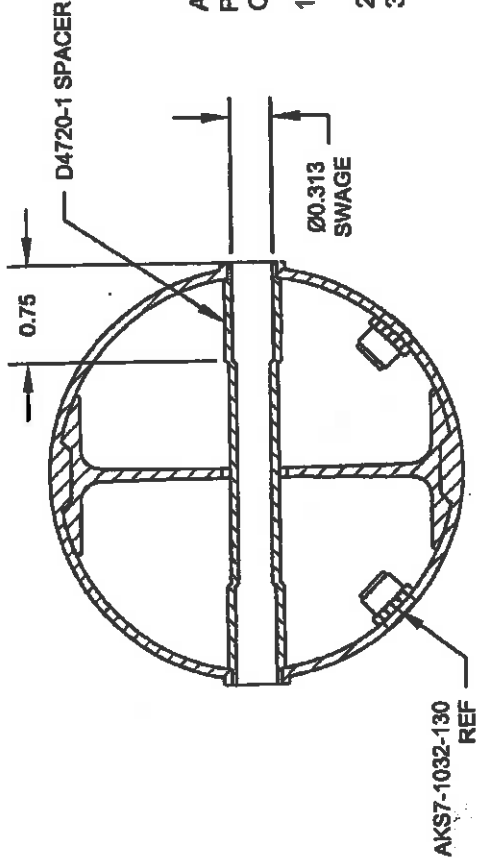
IS:

QTY	QTY	QTY	QTY	DESCRIPTION
-1	-3	-5	-7	
1	1	0	0	CROSS BOLT SPACER
16	17	19	23	D4720-1 SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT
C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).

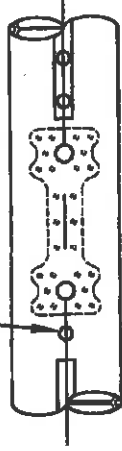


DETAIL G
FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

D2649 SPACER,
WELD PER DETAIL D OF DWG
BUT DO NOT C'BORE



DETAIL B
AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date : _____ Sequence #: _____

QTY Affected : _____

MRB (QS042)

Description Work Order Deviation

Disposition

		Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details:

Entered:

Date:

mid
July 9, 2019

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

19-7259

Route update only



Job: 192087		DISPOSITION		DEPARTMENT/PROCESS	
Part No. D206-642-341.BK		Rework ☒ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐	
Date: 14/5/21	Sequence #:	QTY Affected: 1		MRB (Q51042)	
Description Work Order Deviation		Disposition		INSP 12 of 14/5/21	
Dwg calls for Ø0.625 TOL RING HOLE.		DRILL TOL RING HOLE Ø0.640 Ref. dwg D3274 Rev. 4. 14/5/21		Completed By: 14/5/21	
Root Cause		FAULT CATEGORY		Lead hand / Supervisor Juan Luis Menard 19.07.05	
☒ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		QC / QA Coordinator DAS 55 9-89 July 5, 2019	
☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details:		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	